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IS 3782 (1994): Textiles- Sponge cloth,cotton khadi, grey
[TXD 8: Handloom and Khadi]

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भारतीय मानक

वस्त्रादि — सूती खादी का घूसर रंग का
स्पंज कपड़ा — विशिष्ट

(पहला पुनरीक्षण)

Indian Standard

TEXTILES — SPONGE CLOTH, COTTON
KHADI, GREY — SPECIFICATION

(*First Revision*)

UDC 677.21.074.162.5

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BUREAU OF INDIAN STANDARDS
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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1966. This standard has been revised to overcome difficulties encountered by the khadi industry in implementation of the standard.

Following are the important changes carried out while revising this standard:

- a) Provision for use of two threads of 148 tex (4s) yarn in addition to four threads of 74 tex (8s) yarn in the weft has been made.
- b) For checking the conformity of the sponge cloth to the requirements laid down in this standard a provision has been made for testing of the samples in prevailing atmospheric conditions. However, in case of dispute, the samples shall be tested after conditioning in the standard atmospheric conditions.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — SPONGE CLOTH, COTTON KHADI, GREY — SPECIFICATION

(First Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements of sponge cloth, cotton khadi, grey.

1.2 This standard does not specify the general appearance, feel, shade, etc.

2 REFERENCES

The Indian Standards listed at Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmospheric conditions for checking the conformity of the cloth to the standard. However, in case of dispute, the specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 GENERAL REQUIREMENTS

4.1 Yarn

The yarn used in the manufacture of sponge cloth shall be handspun from clean carded cotton. It shall be reasonably even and free from leaf particles, slubs,

neps and other spinning defects. The approximate count of warp and weft yarn is given in Table 1

4.2 Cloth

The sponge cloth shall be woven in 2/2 twill weave.

4.2.1 The edges of sponge cloth shall be hemmed to a depth of not less than 15 mm with raw edges having a turn-in of 10 mm. The stitching shall be firm and regular. The hemming shall be uniform and flat and the edges shall be properly secured.

4.2.2 Two blue threads shall be running along the length of the sponge cloth at a distance of about 2.5 cm from each side.

4.2.3 The sponge cloth when visually examined, shall be reasonably free from spinning, weaving and processing defects.

4.2.4 The selvedges of the cloth shall be firm and well woven.

5 REQUIREMENTS

5.1 The constructional particulars of the sponge cloth shall conform to the requirements specified in Table 1.

Table 1 Constructional Particulars of Sponge Cloth Cotton Khadi, Grey
(Clauses 4.1 and 5.1)

Count of Yarn (for guidance only)		Ends/dm	Picks/dm	Mass per Piece in g
Universal Count (Cotton count)				
Warp	Weft	(3)	(4)	(5)
(1)	(2)			
30 tex x 2 (120s/2Ne)	74 tex (8s Ne) or 148 tex (4s Ne)	86	78 (Four threads of 8s working together as one) or (Two threads of 4s working together as one)	90
Tolerance, Percent	—	—	±5 see Note	±15
Method of Test	—	—	IS 1963 : 1981	IS 1963 : 1981

NOTE — Any increase in values of ends/dm, picks/dm or mass (g/m²) beyond positive tolerance shall not be a cause of rejection of the cloth.

5.2 Dimensions

Length and width of the sponge cloth when determined in accordance with IS 1954 : 1990 shall be 50 cm and 45 cm respectively. However, a tolerance of ± 1 cm shall be permitted on length and width.

5.3 Sealed Samples

5.3.1 If in order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel, etc, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

5.3.2 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 MARKING

6.1 The sponge cloth shall be legibly marked with the following information :

- a) Name of the material for example sponge cloth, cotton khadi, grey;
- b) Length (cm) and width (cm); and
- c) Indication of the source of manufacture.

6.2 The product may also be marked with Standard Mark.

6.2.1 The use of the Standard Mark is governed by the provisions of Bureau of Indian Standards Act, 1986 and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

7 PACKING

Fold each piece of sponge cloth into a suitable size and arrange a number (say 5 or 10) of folded sponge cloth to form a bundle. Tie each bundle with suitable

string. Unless otherwise agreed, pack these bundles in the form of bale or case in conformity with the procedure laid down in IS 1347 : 1972 or IS 293 : 1980.

8 SAMPLING

8.1 Lot

The quantity of the sponge cloth delivered to buyer against one despatch note shall constitute a lot.

8.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

8.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 2.

Table 2 Sample Size and Permissible Number of Non-conforming Pieces

Lot Size	Sample Size	Permissible Number of Non-conforming Pieces
		(1) (2) (3)
Up to 25	3	0
26 to 50	5	0
51 to 150	8	0
151 to 300	13	1
301 to 500	20	1
501 to 1 000	32	2
1 001 to above	50	3

8.3.1 For selection of samples at random from the lot, procedure given in IS 4905 : 1968 may be followed.

8.4 Number of Samples and Criteria for Conformity

It shall be as follows :

Characteristics	Number of Samples	Criteria for Conformity
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 2	Number of non-conforming pieces shall not exceed the corresponding number given in col 3 of Table 2

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

IS No.	Title	IS No.	Title
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)		and width of fabrics (<i>second revision</i>)
1347 : 1972	Inland packaging of cotton cloth and yarn (<i>first revision</i>)	1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
1954 : 1990	Methods for determination of length	4905 : 1968	Methods for random sampling

ANNEX B

(Table 1)

METHOD FOR DETERMINATION OF MASS PER PIECE

B-1 Measure the length and width of each test specimen correct to the nearest 0.5 cm and determine its mass to nearest 5 g. Calculate the mass of each test specimen of dimensions specified in 5.2.

B-2 Report the lot to be in conformity with the requirement of Table 1 as regards mass per piece of sponge cloth, if the condition laid down in 8.4 is satisfied.

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